

SECTION 03 30 00
CAST-IN-PLACE CONCRETE**PART 1 - GENERAL****1.1 DESCRIPTION**

- A. This section specifies cast-in-place structural concrete and materials and mixes for other concrete.

1.2 RELATED WORK

- A. Materials testing and inspection during construction: Section 01 45 29, TESTING LABORATORY SERVICES.
- B. Concrete roads, walks, and similar exterior site work: Section 32 05 23, CEMENT AND CONCRETE FOR EXTERIOR IMPROVEMENTS.

1.3 TESTING AGENCY FOR CONCRETE MIX DESIGN

- A. Testing agency retained and reimbursed by the Contractor and approved by Resident Engineer.
- B. Testing agency maintaining active participation in Program of Cement and Concrete Reference Laboratory (CCRL) of National Institute of Standards and Technology. Accompany request for approval of testing agency with a copy of Report of Latest Inspection of Laboratory Facilities by CCRL.
- C. Testing agency shall furnish equipment and qualified technicians to establish proportions of ingredients for concrete mixes.

1.4 TOLERANCES

- A. Formwork: ACI 117, except the elevation tolerance of formed surfaces before removal of shores is +0 mm (+0 inch) and -20 mm (-3/4 inch).
- B. Reinforcement Fabricating and Placing: ACI 117, except that fabrication tolerance for bar sizes Nos. 10, 13, and 16 (Nos. 3, 4, and 5) (Tolerance Symbol 1 in Fig. 2.1(a), ACI, 117) used as column ties or stirrups is +0 mm (+0 inch) and -13 mm (-1/2 inch) where gross bar length is less than 3600 mm (12 feet), or +0 mm (+0 inch) and -20 mm (-3/4 inch) where gross bar length is 3600 mm (12 feet) or more.
- C. Cross-Sectional Dimension: ACI 117, except tolerance for thickness of slabs 12 inches or less is +20 mm (+3/4 inch) and - 6 mm (-1/4 inch). Tolerance of thickness of beams more than 300 mm (12 inch) but less than 900 mm (3 feet) is +20 mm (+3/4 inch) and -10 mm (-3/8 inch).
- D. Slab Finishes: ACI 117, Section 4.5.6, F-number method in accordance with ASTM E1155, except as follows:
1. Test entire slab surface, including those areas within 600 mm (2 feet) of construction joints and vertical elements that project through slab surface.

2. Maximum elevation change which may occur within 600 mm (2 feet) of any column or wall element is 6 mm (0.25 inches).
3. Allow sample measurement lines that are perpendicular to construction joints to extend past joint into previous placement no further than 1500 mm (5 feet).

1.5 REGULATORY REQUIREMENTS

- A. ACI SP-66 - ACI Detailing Manual.
- B. ACI 318 - Building Code Requirements for Reinforced Concrete.
- C. ACI 301 - Standard Specifications for Structural Concrete.

1.6 SUBMITTALS

- A. Submit in accordance with Section 01 33 23, SHOP DRAWINGS, PRODUCT DATA, and SAMPLES.
- B. Samples:
 1. Portland cement: 3.5 kg (8 pounds).
 2. Fly ash: 2.25 kg (5 pounds).
- C. Shop Drawings: Reinforcing steel: Complete shop drawings
- D. Mill Test Reports:
 1. Reinforcing Steel.
 2. Cement.
- E. Manufacturer's Certificates:
 1. Abrasive aggregate.
 2. Lightweight aggregate for structural concrete.
 3. Air-entraining admixture.
 4. Chemical admixtures, including chloride ion content.
 5. Waterproof paper for curing concrete.
 6. Liquid membrane-forming compounds for curing concrete.
 7. Non-shrinking grout.
 8. Liquid hardener.
 9. Waterstops.
 10. Expansion joint filler.
 11. Adhesive binder.
- F. Testing Agency for Concrete Mix Design: Approval request including qualifications of principals and technicians and evidence of active participation in program of Cement and Concrete Reference Laboratory (CCRL) of National Institute of Standards and Technology and copy of report of latest CCRL, Inspection of Laboratory.
- G. Test Report for Concrete Mix Designs: Trial mixes including water-cement fly ash ratio curves, concrete mix ingredients, and admixtures.
- H. LEED Information:

1. LEED Credit MR 4.1 and MR 4.2, Recycled Content: Product data indicating percentages, by weight of post-consumer and post-industrial recycled content for products having recycled content.
 - a. Include statement indicating costs for each product having recycled content.
2. LEED Credit MR 5.1 and MR 5.2, Materials Extracted, Processed and Manufactured Regionally: Manufacturer's data identifying point of origin for products procured within a 500 mile radius of the project.
 - a. Include statement indicating costs for each product submitted.

1.7 DELIVERY, STORAGE, AND HANDLING

- A. Conform to ACI 304. Store aggregate separately for each kind or grade, to prevent segregation of sizes and avoid inclusion of dirt and other materials.
- B. Deliver cement in original sealed containers bearing name of brand and manufacturer, and marked with net weight of contents. Store in suitable watertight building in which floor is raised at least 300 mm (1 foot) above ground. Store bulk cement and fly ash in separate suitable bins.
- C. Deliver other packaged materials for use in concrete in original sealed containers, plainly marked with manufacturer's name and brand, and protect from damage until used.

1.8 PRE-CONCRETE CONFERENCE

- A. General: At least 15 days prior to submittal of design mixes, conduct a meeting to review proposed methods of concrete construction to achieve the required results.
- B. Agenda: Includes but is not limited to:
 1. Submittals.
 2. Coordination of work.
 3. Availability of material.
 4. Concrete mix design including admixtures.
 5. Methods of placing, finishing, and curing.
 6. Finish criteria required to obtain required flatness and levelness.
 7. Timing of floor finish measurements.
 8. Material inspection and testing.
- C. Attendees: Include but not limited to representatives of Contractor; subcontractors involved in supplying, conveying, placing, finishing, and curing concrete; lightweight aggregate manufacturer; admixture manufacturers; Resident Engineer; Consulting Engineer; Department of Veterans Affairs retained testing laboratories for concrete testing and finish (F-number) verification.

- D. Minutes of the meeting: Contractor shall take minutes and type and distribute the minutes to attendees within five days of the meeting.

1.9 APPLICABLE PUBLICATIONS

- A. Publications listed below form a part of this specification to extent referenced. Publications are referenced in text by basic designation only.
- B. American Concrete Institute (ACI):
- 117-06.....Tolerances for Concrete Construction and Materials
 - 211.1-02.....Selecting Proportions for Normal, Heavyweight, and Mass Concrete
 - 211.2-04.....Selecting Proportions for Structural Lightweight Concrete
 - 214R-02.....Evaluation of Strength Test Results of Concrete
 - 301-05.....Structural Concrete
 - 304R-2000.....Guide for Measuring, Mixing, Transporting, and Placing Concrete
 - 305R-06.....Hot Weather Concreting
 - 306R-(2002).....Cold Weather Concreting
 - 308R-(2001).....Standard Practice for Curing Concrete
 - 309R-05.....Guide for Consolidation of Concrete
 - 31808.....Building Code Requirements for Reinforced Concrete and Commentary
 - 347R-04.....Guide to Formwork for Concrete
 - SP-66-04.....ACI Detailing Manual
- C. American National Standards Institute and American Hardboard Association (ANSI/AHA):
- A135.4-2004.....Basic Hardboard
- D. American Society for Testing and Materials (ASTM):
- A82/A82M-07.....Steel Wire, Plain, for Concrete Reinforcement
 - A185/185M-07.....Steel Welded Wire Fabric, Plain, for Concrete Reinforcement
 - A615/A615M-08.....Deformed and Plain Billet-Steel Bars for Concrete Reinforcement
 - A653/A653M-07.....Steel Sheet, Zinc-Coated (Galvanized) or Zinc-Iron Alloy-Coated (Galvannealed) by the Hot-Dip Process
 - A706/A706M-06.....Low-Alloy Steel Deformed and Plain Bars for Concrete Reinforcement

A767/A767M-05.....Zinc-Coated (Galvanized) Steel Bars for Concrete Reinforcement

A775/A775M-07.....Epoxy-Coated Reinforcing Steel Bars

A820-06.....Steel Fibers for Fiber-Reinforced Concrete

A996/A996M-06.....Rail-Steel and Axle-Steel Deformed Bars for Concrete Reinforcement

C31/C31M-08.....Making and Curing Concrete Test Specimens in the field

C33-07.....Concrete Aggregates

C39/C39M-05.....Compressive Strength of Cylindrical Concrete Specimens

C94/C94M-07.....Ready-Mixed Concrete

C143/C143M-05.....Slump of Hydraulic Cement Concrete

C150-07.....Portland Cement

C171-07.....Sheet Materials for Curing Concrete

C172-07.....Sampling Freshly Mixed Concrete

C173-07.....Air Content of Freshly Mixed Concrete by the Volumetric Method

C192/C192M-07.....Making and Curing Concrete Test Specimens in the Laboratory

C231-08.....Air Content of Freshly Mixed Concrete by the Pressure Method

C260-06.....Air-Entraining Admixtures for Concrete

C309-07.....Liquid Membrane-Forming Compounds for Curing Concrete

C330-05.....Lightweight Aggregates for Structural Concrete

C494/C494M-08.....Chemical Admixtures for Concrete

C496-06.....Splitting Tensile Strength of Cylindrical Concrete Specimens

C567-05.....Density of Structural Lightweight Concrete

C618-05.....Coal Fly Ash and Raw or Calcined Natural Pozzolan for Use as a Mineral Admixture in Concrete

C666/C666M-03.....Resistance of Concrete to Rapid Freezing and Thawing

C881/C881M-02.....Epoxy-Resin-Base Bonding Systems for Concrete

C1107/1107M-07.....Packaged Dry, Hydraulic-Cement Grout (Non-shrink)

C1315-08.....Liquid Membrane-Forming Compounds Having Special Properties for Curing and Sealing Concrete

- D6-95(R2006).....Loss on Heating of Oil and Asphaltic Compounds
D297-93(R2006).....Rubber Products-Chemical Analysis
D1751-04.....Preformed Expansion Joint Filler for Concrete
Paving and Structural Construction (Non-
extruding and Resilient Bituminous Types)
D4397-02.....Polyethylene Sheeting for Construction,
Industrial and Agricultural Applications
E1155-96(R2008).....Determining F_F Floor Flatness and F_L Floor
Levelness Numbers
- E. American Welding Society (AWS):
D1.4-05.....Structural Welding Code - Reinforcing Steel
- F. Concrete Reinforcing Steel Institute (CRSI):
Handbook 2008
- G. National Cooperative Highway Research Program (NCHRP):
Report On.....Concrete Sealers for the Protection of Bridge
Structures
- H. U. S. Department of Commerce Product Standard (PS):
PS 1.....Construction and Industrial Plywood
PS 20.....American Softwood Lumber
- I. U. S. Army Corps of Engineers Handbook for Concrete and Cement:
CRD C513.....Rubber Waterstops
CRD C572.....Polyvinyl Chloride Waterstops

PART 2 - PRODUCTS**2.1 FORMS**

- A. Wood: PS 20 free from loose knots and suitable to facilitate finishing concrete surface specified; tongue and grooved.
- B. Plywood: PS-1 Exterior Grade B-B (concrete-form) 16 mm (5/8 inch), or 20 mm (3/4 inch) thick for unlined contact form. B-B High Density Concrete Form Overlay optional.
- C. Form Lining:
1. Hardboard: ANSI/AHA A135.4, Class 2 with one (S1S) smooth side)
 2. Plywood: Grade B-B Exterior (concrete-form) not less than 6 mm (1/4 inch) thick.
 3. Plastic, fiberglass, or elastomeric capable of reproducing the desired pattern or texture.
- D. Form Ties: Develop a minimum working strength of 13.35 kN (3000 pounds) when fully assembled. Ties shall be adjustable in length to permit tightening of forms and not have any lugs, cones, washers to act as spreader within form, nor leave a hole larger than 20 mm (3/4 inch) diameter, or a depression in exposed concrete surface, or leave metal

closer than 40 mm (1 1/2 inches) to concrete surface. Wire ties not permitted. Cutting ties back from concrete face not permitted.

2.2 MATERIALS

- A. Portland Cement: ASTM C150 Type I or II.
- B. Fly Ash: ASTM C618, Class C or F including supplementary optional requirements relating to reactive aggregates and alkalis, and loss on ignition (LOI) not to exceed 5 percent.
- C. Coarse Aggregate: ASTM C33.
 - 1. Size 67 or Size 467 may be used for footings and walls over 300 mm (12 inches) thick.
 - 2. Coarse aggregate for applied topping, encasement of steel columns, and metal pan stair fill shall be Size 7.
 - 3. Maximum size of coarse aggregates not more than one-fifth of narrowest dimension between sides of forms, one-third of depth of slabs, nor three-fourth of minimum clear spacing between reinforcing bars.
- D. Lightweight Aggregates for Structural Concrete: ASTM C330, Table 1. Maximum size of aggregate not larger than one-fifth of narrowest dimension between forms, nor three-fourth of minimum clear distance between reinforcing bars. Contractor to furnish certified report to verify that aggregate is sound and durable, and has a durability factor of not less than 80 based on 300 cycles of freezing and thawing when tested in accordance with ASTM C666.
- E. Fine Aggregate: ASTM C33. Fine aggregate for applied concrete floor topping shall pass a 4.75 mm (No. 4) sieve, 10 percent maximum shall pass a 150 μ m (No. 100) sieve.
- F. Mixing Water: Fresh, clean, and potable.
- G. Admixtures:
 - 1. Water Reducing Admixture: ASTM C494, Type A and not contain more chloride ions than are present in municipal drinking water.
 - 2. Water Reducing, Retarding Admixture: ASTM C494, Type D and not contain more chloride ions than are present in municipal drinking water.
 - 3. High-Range Water-Reducing Admixture (Superplasticizer): ASTM C494, Type F or G, and not contain more chloride ions than are present in municipal drinking water.
 - 4. Non-Corrosive, Non-Chloride Accelerator: ASTM C494, Type C or E, and not contain more chloride ions than are present in municipal drinking water. Admixture manufacturer must have long-term non-corrosive test data from an independent testing laboratory of at least one year

- duration using an acceptable accelerated corrosion test method such as that using electrical potential measures.
5. Air Entraining Admixture: ASTM C260.
 6. Prohibited Admixtures: Calcium chloride, thiocyanate or admixtures containing more than 0.05 percent chloride ions are not permitted.
 7. Certification: Written conformance to the requirements above and the chloride ion content of the admixture prior to mix design review.
- H. Vapor Barrier: ASTM D4397, 0.25 mm (10 mil).
- I. Reinforcing Steel: ASTM A615, or ASTM A996, deformed, grade as shown.
- J. Welded Wire Fabric: ASTM A185.
- K. Reinforcing Bars to be Welded: ASTM A706.
- L. Cold Drawn Steel Wire: ASTM A82.
- M. Reinforcement for Metal Pan Stair Fill: 50 mm (2 inch) wire mesh, either hexagonal mesh at .8Kg/m² (1.5 pounds per square yard), or square mesh at .6Kg/m² (1.17 pounds per square yard).
- N. Supports, Spacers, and Chairs: Types which will hold reinforcement in position shown in accordance with requirements of ACI 318 except as specified.
- O. Expansion Joint Filler: ASTM D1751.
- P. Sheet Materials for Curing Concrete: ASTM C171.
- Q. Liquid Membrane-forming Compounds for Curing Concrete: ASTM C309, Type I, with fugitive dye. Compound shall be compatible with scheduled surface treatment, such as paint and resilient tile, and shall not discolor concrete surface.
- R. Abrasive Aggregate: Aluminum oxide grains or emery grits.
- S. Liquid Densifier/Sealer: 100% active colorless aqueous silicate solution.
- T. Non-Shrink Grout:
1. ASTM C1107, pre-mixed, produce a compressive strength of at least 18 MPa at three days and 35 MPa (5000 psi) at 28 days. Furnish test data from an independent laboratory indicating that the grout when placed at a fluid consistency shall achieve 95 percent bearing under a 1200 mm x 1200 mm (4 foot by 4 foot) base plate.
 2. Where high fluidity or increased placing time is required, furnish test data from an independent laboratory indicating that the grout when placed at a fluid consistency shall achieve 95 percent under an 450 mm x 900 mm (18 inch by 36 inch) base plate.
- U. Adhesive Binder: ASTM C881.
1. Polyvinyl Chloride Waterstop: CRD C572.
 2. Rubber Waterstops: CRD C513.

3. Bentonite Water Stop: Flexible strip of bentonite 25 mm x 20 mm (1 inch by 3/4 inch), weighing 8.7 kg/m (5.85 lbs. per foot) composed of Butyl Rubber Hydrocarbon (ASTM D297), Bentonite (SS-S-210-A) and Volatile Matter (ASTM D6).
4. Porous Backfill: Crushed stone or gravel graded from 25 mm to 20 mm (1 inch to 3/4 inch).
5. Synthetic Fibers: Monofilament or fibrillated polypropylene fibers for secondary reinforcing of concrete members. Use appropriate length and 0.9 kg/m^3 (1.5 lb. per cubic yard). Product shall have a UL rating.
6. Epoxy Joint Filler: Two component, 100 percent solids compound, with a minimum shore D hardness of 50.
7. Bonding Admixture: Non-rewettable, polymer modified, bonding compound.
8. Architectural Concrete: For areas designated as architectural concrete on the Contract Documents, use colored cements and specially selected aggregates as necessary to produce a concrete of a color and finish which exactly matches the designated sample panel.

2.3 CONCRETE MIXES

- A. Mix Designs: Proportioned in accordance with Section 5.3, "Proportioning on the Basis of Field Experience and/or Trial Mixtures" of ACI 318.
 1. If trial mixes are used, make a set of at least 6 cylinders in accordance with ASTM C192 for test purposes from each trial mix; test three for compressive strength at 7 days and three at 28 days.
 2. Submit a report of results of each test series, include a detailed listing of the proportions of trial mix or mixes, including cement, fly ash, admixtures, weight of fine and coarse aggregate per m^3 (cubic yard) measured dry rodded and damp loose, specific gravity, fineness modulus, percentage of moisture, air content, water-cement -fly ash ratio, and consistency of each cylinder in terms of slump. Include dry unit weight of lightweight structural concrete.
 3. Prepare a curve showing relationship between water-cement -fly ash ratio at 7-day and 28-day compressive strengths. Plot each curve using at least three specimens.
 4. If the field experience method is used, submit complete standard deviation analysis.
- B. Fly Ash Testing: Submit certificate verifying conformance with specifications initially with mix design and for each truck load of fly ash delivered from source. Notify Resident Engineer immediately when change in source is anticipated. Prior to beginning trial mixes submit

to the Resident Engineer the following representative samples of material to be used, properly identified source and project description and number, type of testing (complete chemical and physical), suitably packaged for shipment, and addressed as specified. Allow 60 calendar days for test results after submittal of sample.

1. Fly ash - 2.25 kg (five pounds).

2. Portland cement - 3.5 kg (8 pounds):

Address -Waterways Experiment Station (WES)

3909 Halls Ferry Road

Vicksburg, MS 39180-6199

ATTN: Engineering Materials Group

- C. After approval of mixes no substitution in material or change in proportions of approval mixes may be made without additional tests and approval of Resident Engineer or as specified. Making and testing of preliminary test cylinders may be carried on pending approval of cement and fly ash, providing Contractor and manufacturer certify that ingredients used in making test cylinders are the same. Resident Engineer may allow Contractor to proceed with depositing concrete for certain portions of work, pending final approval of cement and fly ash and approval of design mix.
- D. Cement Factor: Maintain minimum cement factors in Table I regardless of compressive strength developed above minimums. Fly ash may be substituted for up to 20 percent of the minimum cement factor at option of Contractor, except fly ash may not be used in concrete designated as architectural concrete.

TABLE I - CEMENT AND WATER FACTORS FOR CONCRETE

Concrete Strength		Non-Air-Entrained	Air-Entrained	
Min. 28 Day Comp. Str. MPa (psi)	Min. Cement kg/m ³ (lbs/c. yd)	Max. Water Cement Ratio	Min. Cement kg/m ³ (lbs/c. yd)	Max. Water Cement Ratio
30 (4000) ^{1,3}	325 (550)	0.55	340 (570)	0.50
24 (3500) ^{1,2}	300 (500)	*	310 (520)	*
25 (3000) ^{1,3}	280 (470)	0.65	290 (490)	0.55

1. If trial mixes are used, the proposed mix design shall achieve a compressive strength 8.3 MPa (1200 psi) in excess of f'c. For concrete strengths above 35 Mpa (5000 psi), the proposed mix design shall achieve a compressive strength 9.7 MPa (1400 psi) in excess of f'c.

2. Lightweight Structural Concrete. Pump mixes may require higher cement values.

3. For concrete exposed to high sulfate content soils maximum water cement ratio is 0.44.

* Determined by Laboratory in accordance with ACI 211.1 for normal concrete or ACI 211.2 for lightweight structural concrete.

E. Maximum Slump: Maximum slump, as determined by ASTM C143 with tolerances as established by ASTM C94, for concrete to be vibrated shall be as shown in Table II.

TABLE II - MAXIMUM SLUMP, MM (INCHES)*

Type of Construction	Normal Weight Concrete	Lightweight Structural Concrete
Reinforced Footings and Substructure Walls	75mm (3 inches)	75 mm (3 inches)
Slabs, Beams, Reinforced Walls, and Building Columns	100 mm (4 inches)	100 mm (4 inches)

* Slump may be increased by the use of the approved high-range water-reducing admixture (superplasticizer). Tolerances as established by ASTM C94. Concrete containing the high-range-water-reducing admixture may have a maximum slump of 225 mm (9 inches). The concrete shall arrive at the job site at a slump of 50 mm to 75 mm (2 inches to 3 inches), and 75 mm to 100 mm (3 inches to 4 inches) for lightweight concrete. This should be verified, and then the high-range-water-reducing admixture added to increase the slump to the approved level.

F. Air-Entrainment: Air-entrainment of normal weight concrete shall conform with Table III. Air-entrainment of lightweight structural concrete shall conform with Table IV. Determine air content by either ASTM C173 or ASTM C231.

**TABLE III - TOTAL AIR CONTENT
FOR VARIOUS SIZES OF COARSE AGGREGATES (NORMAL CONCRETE)**

Nominal Maximum Size of Total Air Content	Coarse Aggregate, mm (Inches) Percentage by Volume
10 mm (3/8 in).6 to 10	13 mm (1/2 in).5 to 9
20 mm (3/4 in).4 to 8	25 mm (1 in).3-1/2 to 6-1/2
40 mm (1 1/2 in).3 to 6	

TABLE IV
AIR CONTENT OF LIGHTWEIGHT STRUCTURAL CONCRETE

Nominal Maximum size of Total Air Content	Coarse Aggregate, mm's (Inches) Percentage by Volume
Greater than 10 mm (3/8 in) 4 to 8	10 mm (3/8 in) or less 5 to 9

- G. High early strength concrete, made with Type III cement or Type I cement plus non-corrosive accelerator, shall have a 7-day compressive strength equal to specified minimum 28-day compressive strength for concrete type specified made with standard Portland cement.
- H. Lightweight structural concrete shall not weigh more than air-dry unit weight shown. Air-dry unit weight determined on 150 mm by 300 mm (6 inch by 12 inch) test cylinders after seven days standard moist curing followed by 21 days drying at 23 degrees C \pm 1.7 degrees C (73.4 \pm 3 degrees Fahrenheit), and 50 (plus or minus 7) percent relative humidity. Use wet unit weight of fresh concrete as basis of control in field.
- I. Concrete slabs placed at air temperatures below 10 degrees C (50 degrees Fahrenheit) use non-corrosive, non-chloride accelerator. Concrete required to be air entrained use approved air entraining admixture. Pumped concrete, synthetic fiber concrete, architectural concrete, concrete required to be watertight, and concrete with a water/cement ratio below 0.50 use high-range water-reducing admixture (superplasticizer).
- J. Durability: Use air entrainment for exterior exposed concrete subjected to freezing and thawing and other concrete shown or specified. Air content as shown in Table III or Table IV.
- K. Enforcing Strength Requirements: Test as specified in Section 01 45 29, TESTING LABORATORY SERVICES, during the progress of the work. Seven-day tests may be used as indicators of 28-day strength. Average of any three 28-day consecutive strength tests of laboratory-cured specimens representing each type of concrete shall be equal to or greater than specified strength. No single test shall be more than 3.5 MPa (500 psi) below specified strength. Interpret field test results in accordance with ACI 214. Should strengths shown by test specimens fall below required values, Resident Engineer may require any one or any combination of the following corrective actions, at no additional cost to the Government:

1. Require changes in mix proportions by selecting one of the other appropriate trial mixes or changing proportions, including cement content, of approved trial mix.
2. Require additional curing and protection.
3. If five consecutive tests fall below 95 percent of minimum values given in Table I or if test results are so low as to raise a question as to the safety of the structure, Resident Engineer may direct Contractor to take cores from portions of the structure. Use results from cores tested by the Contractor retained testing agency to analyze structure.
4. If strength of core drilled specimens falls below 85 percent of minimum value given in Table I, Resident Engineer may order load tests, made by Contractor retained testing agency, on portions of building so affected. Load tests in accordance with ACI 318 and criteria of acceptability of concrete under test as given therein.
5. Concrete work, judged inadequate by structural analysis, by results of load test, or for any reason, shall be reinforced with additional construction or replaced, if directed by the Resident Engineer.

2.4 BATCHING AND MIXING

- A. General: Concrete shall be "Ready-Mixed" and comply with ACI 318 and ASTM C94, except as specified. Batch mixing at the site is permitted. Mixing process and equipment must be approved by Resident Engineer. With each batch of concrete, furnish certified delivery tickets listing information in Paragraph 16.1 and 16.2 of ASTM C94. Maximum delivery temperature of concrete is 38°C (100 degrees Fahrenheit). Minimum delivery temperature as follows:

Atmospheric Temperature	Minimum Concrete Temperature
-1. degrees to 4.4 degrees C (30 degrees to 40 degrees F)	15.6 degrees C (60 degrees F.)
-17 degrees C to -1.1 degrees C (0 degrees to 30 degrees F.)	21 degrees C (70 degrees F.)

1. Services of aggregate manufacturer's representative shall be furnished during the design of trial mixes and as requested by the Resident Engineer for consultation during batching, mixing, and placing operations of lightweight structural concrete. Services will be required until field controls indicate that concrete of required quality is being furnished. Representative shall be thoroughly familiar with the structural lightweight aggregate, adjustment and

control of mixes to produce concrete of required quality.

Representative shall assist and advise Resident Engineer.

PART 3 - EXECUTION

3.1 FORMWORK

- A. General: Design in accordance with ACI 347 is the responsibility of the Contractor. The Contractor shall retain a registered Professional Engineer to design the formwork, shores, and reshores.
 - 1. Form boards and plywood forms may be reused for contact surfaces of exposed concrete only if thoroughly cleaned, patched, and repaired and Resident Engineer approves their reuse.
 - 2. Provide forms for concrete footings unless Resident Engineer determines forms are not necessary.
 - 3. Corrugated fiberboard forms: Place forms on a smooth firm bed, set tight, with no buckled cartons to prevent horizontal displacement, and in a dry condition when concrete is placed.
- B. Treating and Wetting: Treat or wet contact forms as follows:
 - 1. Coat plywood and board forms with non-staining form sealer. In hot weather, cool forms by wetting with cool water just before concrete is placed.
 - 2. Clean and coat removable metal forms with light form oil before reinforcement is placed. In hot weather, cool metal forms by thoroughly wetting with water just before placing concrete.
 - 3. Use sealer on reused plywood forms as specified for new material.
- C. Size and Spacing of Studs: Size and space studs, wales and other framing members for wall forms so as not to exceed safe working stress of kind of lumber used nor to develop deflection greater than $1/270$ of free span of member.
- D. Unlined Forms: Use plywood forms to obtain a smooth finish for concrete surfaces. Tightly butt edges of sheets to prevent leakage. Back up all vertical joints solidly and nail edges of adjacent sheets to same stud with 6d box nails spaced not over 150 mm (6 inches) apart.
- E. Lined Forms: May be used in lieu of unlined plywood forms. Back up form lining solidly with square edge board lumber securely nailed to studs with all edges in close contact to prevent bulging of lining. No joints in lining and backing may coincide. Nail abutted edges of sheets to same backing board. Nail lining at not over 200 mm (8 inches) on center along edges and with at least one nail to each square foot of surface area; nails to be 3d blued shingle or similar nails with thin flatheads.
- F. Architectural Liner: Attach liner as recommended by the manufacturer with tight joints to prevent leakage.

G. Wall Form Ties: Locate wall form ties in symmetrically level horizontal rows at each line of wales and in plumb vertical tiers. Space ties to maintain true, plumb surfaces. Provide one row of ties within 150 mm (6 inches) above each construction joint. Space through-ties adjacent to horizontal and vertical construction joints not over 450 mm (18 inches) on center.

1. Tighten row of ties at bottom of form just before placing concrete and, if necessary, during placing of concrete to prevent seepage of concrete and to obtain a clean line. Ties to be entirely removed shall be loosened 24 hours after concrete is placed and shall be pulled from least important face when removed.
2. Coat surfaces of all metal that is to be removed with paraffin, cup grease or a suitable compound to facilitate removal.

H. Inserts, Sleeves, and Similar Items: Flashing reglets, steel strips, masonry ties, anchors, wood blocks, nailing strips, grounds, inserts, wire hangers, sleeves, drains, guard angles, forms for floor hinge boxes, inserts or bond blocks for elevator guide rails and supports, and other items specified as furnished under this and other sections of specifications and required to be in their final position at time concrete is placed shall be properly located, accurately positioned, and built into construction, and maintained securely in place.

1. Locate inserts or hanger wires for furred and suspended ceilings only in bottom of concrete joists, or similar concrete member of overhead concrete joist construction.
2. Install sleeves, inserts and similar items for mechanical services in accordance with drawings prepared specially for mechanical services. Contractor is responsible for accuracy and completeness of drawings and shall coordinate requirements for mechanical services and equipment.
3. Do not install sleeves in beams, joists or columns except where shown or permitted by Resident Engineer. Install sleeves in beams, joists, or columns that are not shown, but are permitted by the Resident Engineer, and require no structural changes, at no additional cost to the Government.
4. Minimum clear distance of embedded items such as conduit and pipe is at least three times diameter of conduit or pipe, except at stub-ups and other similar locations.
5. Provide recesses and blockouts in floor slabs for door closers and other hardware as necessary in accordance with manufacturer's instructions.

I. Construction Tolerances:

1. Set and maintain concrete formwork to assure erection of completed work within tolerances specified and to accommodate installation of other rough and finish materials. Accomplish remedial work necessary for correcting excessive tolerances. Erected work that exceeds specified tolerance limits shall be remedied or removed and replaced, at no additional cost to the Government.
2. Permissible surface irregularities for various classes of materials are defined as "finishes" in specification sections covering individual materials. They are to be distinguished from tolerances specified which are applicable to surface irregularities of structural elements.

3.2 PLACING REINFORCEMENT

- A. General: Details of concrete reinforcement in accordance with ACI 318 and ACI 315, unless otherwise shown.
- B. Placing: Place reinforcement conforming to CRSI DA4, unless otherwise shown.
 1. Place reinforcing bars accurately and tie securely at intersections and splices with 1.6 mm (16 gauge) black annealed wire. Use epoxy-coated tie wire with epoxy-coated reinforcing. Secure reinforcing bars against displacement during the placing of concrete by spacers, chairs, or other similar supports. Portions of supports, spacers, and chairs in contact with formwork shall be made of plastic in areas that will be exposed when building is occupied. Type, number, and spacing of supports conform to ACI 315. Where concrete slabs are placed on ground, use concrete blocks or other non-corrodible material of proper height, for support of reinforcement. Use of brick or stone supports will not be permitted.
 2. Lap welded wire fabric at least 1 1/2 mesh panels plus end extension of wires not less than 300 mm (12 inches) in structural slabs. Lap welded wire fabric at least 1/2 mesh panels plus end extension of wires not less than 150 mm (6 inches) in slabs on grade.
 3. Splice column steel at no points other than at footings and floor levels unless otherwise shown.
- C. Spacing: Minimum clear distances between parallel bars, except in columns and multiple layers of bars in beams shall be equal to nominal diameter of bars. Minimum clear spacing is 25 mm (1 inch) or 1-1/3 times maximum size of coarse aggregate.
- D. Splicing: Splices of reinforcement made only as required or shown or specified. Accomplish splicing as follows:

1. Lap splices: Do not use lap splices for bars larger than Number 36 (Number 11). Minimum lengths of lap as shown.
2. Welded splices: Splicing by butt-welding of reinforcement permitted providing the weld develops in tension at least 125 percent of the yield strength (fy) for the bars. Welding conform to the requirements of AWS D1.4. Welded reinforcing steel conform to the chemical analysis requirements of AWS D1.4.
 - a. Submit test reports indicating the chemical analysis to establish weldability of reinforcing steel.
 - b. Submit a field quality control procedure to insure proper inspection, materials and welding procedure for welded splices.
 - c. Department of Veterans Affairs retained testing agency shall test a minimum of three splices, for compliance, locations selected by Resident Engineer.
3. Mechanical Splices: Develop in tension and compression at least 125 percent of the yield strength (fy) of the bars. Stresses of transition splices between two reinforcing bar sizes based on area of smaller bar. Provide mechanical splices at locations indicated. Use approved exothermic, tapered threaded coupling, or swaged and threaded sleeve. Exposed threads and swaging in the field not permitted.
 - a. Initial qualification: In the presence of Resident Engineer, make three test mechanical splices of each bar size proposed to be spliced. Department of Veterans Affairs retained testing laboratory will perform load test.
 - b. During installation: Furnish, at no additional cost to the Government, one companion (sister) splice for every 50 splices for load testing. Department of Veterans Affairs retained testing laboratory will perform the load test.
- E. Bending: Bend bars cold, unless otherwise approved. Do not field bend bars partially embedded in concrete, except when approved by Resident Engineer.
- F. Cleaning: Metal reinforcement, at time concrete is placed, shall be free from loose flaky rust, mud, oil, or similar coatings that will reduce bond.
- G. Future Bonding: Protect exposed reinforcement bars intended for bonding with future work by wrapping with felt and coating felt with a bituminous compound unless otherwise shown.

3.3 VAPOR BARRIER

- A. Except where membrane waterproofing is required, interior concrete slab on grade shall be placed on a continuous vapor barrier.
 - 1. Place 100 mm (4 inches) of fine granular fill over the vapor barrier to act as a blotter for concrete slab.
 - 2. Vapor barrier joints lapped 150 mm (6 inches) and sealed with compatible waterproof pressure-sensitive tape.
 - 3. Patch punctures and tears.

3.4 MOISTURE VAPOR EMISSIONS & ALKALINITY CONTROL SEALER

- A. Sealer is applied on the day of the concrete pour or as as soon as harsh weather permits, prior to any other chemical treatments for concrete slabs either on grade, below grade or above grade receiving resilient flooring, such as, sheet vinyl, vinyl composition tile, rubber, wood flooring, carpet, epoxy coatings and overlays.
- B. Manufacturer's representative will be on the site the day of concrete pour to install or train its application and document. He shall return on every application thereafter to verify that proper procedures are followed.
 - 1. Apply Sealer to concrete slabs as soon as final finishing operations are complete and the concrete has hardened sufficiently to sustain floor traffic without damage.
 - 2. Spray apply Sealer at the rate of 20 m² (200 square feet) per gallon. Lightly broom product evenly over the substrate and product has completely penetrated the surface.
 - 3. If within two (2) hours after initial application areas are subjected to heavy rainfall and puddling occurs, reapply Sealer product to these areas as soon as weather condition permits.

3.5 CONSTRUCTION JOINTS

- A. Unless otherwise shown, location of construction joints to limit individual placement shall not exceed 24,000 mm (80 feet) in any horizontal direction, except slabs on grade which shall have construction joints shown. Allow 48 hours to elapse between pouring adjacent sections unless this requirement is waived by Resident Engineer.
- B. Locate construction joints in suspended floors near the quarter-point of spans for slabs, beams or girders, unless a beam intersects a girder at center, in which case joint in girder shall be offset a distance equal to twice width of beam. Provide keys and inclined dowels as shown. Provide longitudinal keys as shown.

- C. Place concrete for columns slowly and in one operation between joints. Install joints in concrete columns at underside of deepest beam or girder framing into column.
- D. Allow 2 hours to elapse after column is cast before concrete of supported beam, girder or slab is placed. Place girders, beams, grade beams, column capitals, brackets, and haunches at the same time as slab unless otherwise shown.
- E. Install polyvinyl chloride or rubber water seals, as shown in accordance with manufacturer's instructions, to form continuous watertight seal.

3.6 EXPANSION JOINTS

- A. Clean expansion joint surfaces before installing premolded filler and placing adjacent concrete.
- B. Install polyvinyl chloride or rubber water seals, as shown in accordance with manufacturer's instructions, to form continuous watertight seal.

3.7 PLACING CONCRETE

- A. Preparation:
 - 1. Remove hardened concrete, wood chips, shavings and other debris from forms.
 - 2. Remove hardened concrete and foreign materials from interior surfaces of mixing and conveying equipment.
 - 3. Have forms and reinforcement inspected and approved by Resident Engineer before depositing concrete.
 - 4. Provide runways for wheeling equipment to convey concrete to point of deposit. Keep equipment on runways which are not supported by or bear on reinforcement. Provide similar runways for protection of vapor barrier on coarse fill.
- B. Bonding: Before depositing new concrete on or against concrete which has been set, thoroughly roughen and clean existing surfaces of laitance, foreign matter, and loose particles.
 - 1. Preparing surface for applied topping:
 - a. Remove laitance, mortar, oil, grease, paint, or other foreign material by sand blasting. Clean with vacuum type equipment to remove sand and other loose material.
 - b. Broom clean and keep base slab wet for at least four hours before topping is applied.
 - c. Use a thin coat of one part Portland cement, 1.5 parts fine sand, bonding admixture; and water at a 50: 50 ratio and mix to achieve the consistency of thick paint. Apply to a damp base slab by scrubbing with a stiff fiber brush. New concrete shall be placed while the bonding grout is still tacky.

- C. Conveying Concrete: Convey concrete from mixer to final place of deposit by a method which will prevent segregation. Method of conveying concrete subject to approval of Resident Engineer.
- D. Placing: For special requirements see Paragraphs, HOT WEATHER and COLD WEATHER.
1. Do not place concrete when weather conditions prevent proper placement and consolidation, or when concrete has attained its initial set, or has contained its water or cement content more than 1 1/2 hours.
 2. Deposit concrete in forms as near as practicable in its final position. Prevent splashing of forms or reinforcement with concrete in advance of placing concrete.
 3. Do not drop concrete freely more than 3000 mm (10 feet) for concrete containing the high-range water-reducing admixture (superplasticizer) or 1500 mm (5 feet) for conventional concrete. Where greater drops are required, use a tremie or flexible spout (canvas elephant trunk), attached to a suitable hopper.
 4. Discharge contents of tremies or flexible spouts in horizontal layers not exceeding 500 mm (20 inches) in thickness, and space tremies such as to provide a minimum of lateral movement of concrete.
 5. Continuously place concrete until an entire unit between construction joints is placed. Rate and method of placing concrete shall be such that no concrete between construction joints will be deposited upon or against partly set concrete, after it's initial set has taken place, or after 45 minutes of elapsed time during concrete placement.
 6. On bottom of members with severe congestion of reinforcement, deposit 25 mm (1 inch) layer of flowing concrete containing the specified high-range water-reducing admixture (superplasticizer). Successive concrete lifts may be a continuation of this concrete or concrete with a conventional slump.
 7. Concrete on metal deck:
 - a. Concrete on metal deck shall be minimum thickness shown. Allow for deflection of steel beams and metal deck under the weight of wet concrete in calculating concrete quantities for slab.
 - 1) The Contractor shall become familiar with deflection characteristics of structural frame to include proper amount of additional concrete due to beam/deck deflection.
- E. Consolidation: Conform to ACI 309. Immediately after depositing, spade concrete next to forms, work around reinforcement and into angles of forms, tamp lightly by hand, and compact with mechanical vibrator

applied directly into concrete at approximately 450 mm (18 inch) intervals. Mechanical vibrator shall be power driven, hand operated type with minimum frequency of 5000 cycles per minute having an intensity sufficient to cause flow or settlement of concrete into place. Vibrate concrete to produce thorough compaction, complete embedment of reinforcement and concrete of uniform and maximum density without segregation of mix. Do not transport concrete in forms by vibration.

1. Use of form vibration shall be approved only when concrete sections are too thin or too inaccessible for use of internal vibration.
2. Carry on vibration continuously with placing of concrete. Do not insert vibrator into concrete that has begun to set.

3.8 HOT WEATHER

- A. Follow the recommendations of ACI 305 or as specified to prevent problems in the manufacturing, placing, and curing of concrete that can adversely affect the properties and serviceability of the hardened concrete. Methods proposed for cooling materials and arrangements for protecting concrete shall be made in advance of concrete placement and approved by Resident Engineer.

3.9 COLD WEATHER

- A. Follow the recommendations of ACI 306 or as specified to prevent freezing of concrete and to permit concrete to gain strength properly. Use only the specified non-corrosive, non-chloride accelerator. Do not use calcium chloride, thiocyanates or admixtures containing more than 0.05 percent chloride ions. Methods proposed for heating materials and arrangements for protecting concrete shall be made in advance of concrete placement and approved by Resident Engineer.

3.10 PROTECTION AND CURING

- A. Conform to ACI 308: Initial curing shall immediately follow the finishing operation. Protect exposed surfaces of concrete from premature drying, wash by rain and running water, wind, mechanical injury, and excessively hot or cold temperatures. Keep concrete not covered with membrane or other curing material continuously wet for at least 7 days after placing, except wet curing period for high-early-strength concrete shall be not less than 3 days. Keep wood forms continuously wet to prevent moisture loss until forms are removed. Cure exposed concrete surfaces as described below. Other curing methods may be used if approved by Resident Engineer.
 1. Liquid curing and sealing compounds: Apply by power-driven spray or roller in accordance with the manufacturer's instructions. Apply immediately after finishing. Maximum coverage 10m²/L (400 square feet

- per gallon) on steel troweled surfaces and 7.5m²/L (300 square feet per gallon) on floated or broomed surfaces for the curing/sealing compound.
2. Plastic sheets: Apply as soon as concrete has hardened sufficiently to prevent surface damage. Utilize widest practical width sheet and overlap adjacent sheets 50 mm (2 inches). Tightly seal joints with tape.
 3. Paper: Utilize widest practical width paper and overlap adjacent sheets 50 mm (2 inches). Tightly seal joints with sand, wood planks, pressure-sensitive tape, mastic or glue.

3.11 REMOVAL OF FORMS

- A. Remove in a manner to assure complete safety of structure after the following conditions have been met.
 1. Where structure as a whole is supported on shores, forms for beams and girder sides, columns, and similar vertical structural members may be removed after 24 hours, provided concrete has hardened sufficiently to prevent surface damage and curing is continued without any lapse in time as specified for exposed surfaces.
 2. Take particular care in removing forms of architectural exposed concrete to insure surfaces are not marred or gouged, and that corners and arises are true, sharp and unbroken.
- B. Control Test: Use to determine if the concrete has attained sufficient strength and curing to permit removal of supporting forms. Cylinders required for control tests taken in accordance with ASTM C172, molded in accordance with ASTM C31, and tested in accordance with ASTM C39. Control cylinders cured and protected in the same manner as the structure they represent. Supporting forms or shoring not removed until strength of control test cylinders have attained at least 70 percent of minimum 28-day compressive strength specified. Exercise care to assure that newly unsupported portions of structure are not subjected to heavy construction or material loading.

3.12 CONCRETE SURFACE PREPARATION

- A. Metal Removal: Unnecessary metal items cut back flush with face of concrete members.
- B. Patching: Maintain curing and start patching as soon as forms are removed. Do not apply curing compounds to concrete surfaces requiring patching until patching is completed. Use cement mortar for patching of same composition as that used in concrete. Use white or gray Portland cement as necessary to obtain finish color matching surrounding concrete. Thoroughly clean areas to be patched. Cut out honeycombed or

otherwise defective areas to solid concrete to a depth of not less than 25 mm (1 inch). Cut edge perpendicular to surface of concrete. Saturate with water area to be patched, and at least 150 mm (6 inches) surrounding before placing patching mortar. Give area to be patched a brush coat of cement grout followed immediately by patching mortar. Cement grout composed of one part Portland cement, 1.5 parts fine sand, bonding admixture, and water at a 50:50 ratio, mix to achieve consistency of thick paint. Mix patching mortar approximately 1 hour before placing and remix occasionally during this period without addition of water. Compact mortar into place and screed slightly higher than surrounding surface. After initial shrinkage has occurred, finish to match color and texture of adjoining surfaces. Cure patches as specified for other concrete. Fill form tie holes which extend entirely through walls from unexposed face by means of a pressure gun or other suitable device to force mortar through wall. Wipe excess mortar off exposed face with a cloth.

- C. Upon removal of forms, clean vertical concrete surface that is to receive bonded applied cementitious application with wire brushes or by sand blasting to remove unset material, laitance, and loose particles to expose aggregates to provide a clean, firm, granular surface for bond of applied finish.

3.13 CONCRETE FINISHES

A. Vertical and Overhead Surface Finishes:

1. Unfinished areas: Vertical and overhead concrete surfaces exposed in pipe basements, elevator and dumbwaiter shafts, pipe spaces, pipe trenches, above suspended ceilings, manholes, and other unfinished areas will not require additional finishing.
2. Interior and exterior exposed areas to be painted: Remove fins, burrs and similar projections on surfaces flush, and smooth by mechanical means approved by Resident Engineer, and by rubbing lightly with a fine abrasive stone or hone. Use ample water during rubbing without working up a lather of mortar or changing texture of concrete.
3. Interior and exterior exposed areas finished: Give a grout finish of uniform color and smooth finish treated as follows:
 - a. After concrete has hardened and laitance, fins and burrs removed, scrub concrete with wire brushes. Clean stained concrete surfaces by use of a hone stone.
 - b. Apply grout composed of one part of Portland cement, one part fine sand, smaller than a 600 μ m (No. 30) sieve. Work grout into

surface of concrete with cork floats or fiber brushes until all pits, and honeycombs are filled.

- c. After grout has hardened slightly, but while still plastic, scrape grout off with a sponge rubber float and, about 1 hour later, rub concrete vigorously with burlap to remove any excess grout remaining on surfaces.
 - d. In hot, dry weather use a fog spray to keep grout wet during setting period. Complete finish of area in same day. Make limits of finished areas at natural breaks in wall surface. Leave no grout on concrete surface overnight.
4. Textured: Finish as specified. Maximum quantity of patched area 0.2 m² (2 square feet) in each 93 m² (1000 square feet) of textured surface.

B. Slab Finishes:

1. Monitoring and Adjustment: Provide continuous cycle of placement, measurement, evaluation and adjustment of procedures to produce slabs within specified tolerances. Monitor elevations of structural steel in key locations before and after concrete placement to establish typical deflection patterns for the structural steel. Determine elevations of cast-in-place slab soffits prior to removal of shores. Provide information to Resident Engineer and floor consultant for evaluation and recommendations for subsequent placements.
2. Set perimeter forms to serve as screed using either optical or laser instruments. For slabs on grade, wet screeds may be used to establish initial grade during strike-off, unless Resident Engineer determines that the method is proving insufficient to meet required finish tolerances and directs use of rigid screed guides. Where wet screeds are allowed, they shall be placed using grade stakes set by optical or laser instruments. Use rigid screed guides, as opposed to wet screeds, to control strike-off elevation for all types of elevated (non slab-on-grade) slabs. Divide bays into halves or thirds by hard screeds. Adjust as necessary where monitoring of previous placements indicates unshored structural steel deflections to other than a level profile.
3. Place slabs monolithically. Once slab placement commences, complete finishing operations within same day. Slope finished slab to floor drains where they occur, whether shown or not.
4. Use straightedges specifically made for screeding, such as hollow magnesium straightedges or power strike-offs. Do not use pieces of dimensioned lumber. Strike off and screed slab to a true surface at

- required elevations. Use optical or laser instruments to check concrete finished surface grade after strike-off. Repeat strike-off as necessary. Complete screeding before any excess moisture or bleeding water is present on surface. Do not sprinkle dry cement on the surface.
5. Immediately following screeding, and before any bleed water appears, use a 3000 mm (10 foot) wide highway straightedge in a cutting and filling operation to achieve surface flatness. Do not use bull floats or darbys, except that darbying may be allowed for narrow slabs and restricted spaces.
 6. Wait until water sheen disappears and surface stiffens before proceeding further. Do not perform subsequent operations until concrete will sustain foot pressure with maximum of 6 mm (1/4 inch) indentation.
 7. Scratch Finish: Finish base slab to receive a bonded applied cementitious application as indicated above, except that bull floats and darbys may be used. Thoroughly coarse wire broom within two hours after placing to roughen slab surface to insure a permanent bond between base slab and applied materials.
 8. Float Finish: Slabs to receive unbonded toppings, steel trowel finish, fill, mortar setting beds, or a built-up roof, and ramps, stair treads, platforms (interior and exterior), and equipment pads shall be floated to a smooth, dense uniform, sandy textured finish. During floating, while surface is still soft, check surface for flatness using a 3000 mm (10 foot) highway straightedge. Correct high spots by cutting down and correct low spots by filling in with material of same composition as floor finish. Remove any surface projections and re-float to a uniform texture.
 9. Steel Trowel Finish: Concrete surfaces to receive resilient floor covering or carpet, monolithic floor slabs to be exposed to view in finished work, future floor roof slabs, applied toppings, and other interior surfaces for which no other finish is indicated. Steel trowel immediately following floating. During final troweling, tilt steel trowel at a slight angle and exert heavy pressure to compact cement paste and form a dense, smooth surface. Finished surface shall be smooth, free of trowel marks, and uniform in texture and appearance.
 10. Broom Finish: Finish exterior slabs, ramps, and stair treads with a bristle brush moistened with clear water after surfaces have been

floated. Brush in a direction transverse to main traffic. Match texture approved by Resident Engineer from sample panel.

11. Finished slab flatness (FF) and levelness (FL) values comply with the following minimum requirements:

- a. Areas covered with carpeting, or not specified otherwise in b. below:

Slab on Grade:

Specified overall value F_F 25/ F_L 20

Minimum local value F_F 17/ F_L 15

Level suspended slabs (shored until after testing) and topping slabs:

Specified overall value FF 25/FL 20

Minimum local value FF 17/FL 15

Unshored suspended slabs:

Specified overall value FF 25

Minimum local value FF 17

Level tolerance such that 80 percent of all points fall within a 20 mm (3/4 inch) envelope +10 mm, -10 mm (+3/8 inch, -3/8 inch) from the design elevation.

- b. Areas that will be exposed, receive thin-set tile or resilient flooring, or roof areas designed as future floors:

Slab on grade:

Specified overall value FF 36/FL 20

Minimum local value FF 24/FL 15

Level suspended slabs (shored until after testing) and topping slabs

Specified overall value FF 30/FL 20

Minimum local value FF 24/FL 15

Unshored suspended slabs:

Specified overall value FF 30

Minimum local value FF 24

Level tolerance such that 80 percent of all points fall within a 20 mm (3/4 inch) envelope +10 mm, -10 mm (+3/8 inch, -3/8 inch) from the design elevation.

- c. "Specified overall value" is based on the composite of all measured values in a placement derived in accordance with ASTM E1155.
- d. "Minimum local value" (MLV) describes the flatness or levelness below which repair or replacement is required. MLV is based on the results of an individual placement and applies to a minimum local

area. Minimum local area boundaries may not cross a construction joint or expansion joint. A minimum local area will be bounded by construction and/or control joints, or by column lines and/or half-column lines, whichever is smaller.

12. Measurements

- a. Department of Veterans Affairs retained testing laboratory will take measurements as directed by Resident Engineer, to verify compliance with F_F , F_L , and other finish requirements. Measurements will occur within 72 hours after completion of concrete placement (weekends and holidays excluded). Make measurements before shores or forms are removed to insure the "as-built" levelness is accurately assessed. Profile data for above characteristics may be collected using a laser level or any Type II apparatus (ASTM E1155, "profileograph" or "dipstick"). Contractor's surveyor shall establish reference elevations to be used by Department of Veterans Affairs retained testing laboratory.
- b. Contractor not experienced in using F_F and F_L criteria is encouraged to retain the services of a floor consultant to assist with recommendations concerning adjustments to slab thicknesses, finishing techniques, and procedures on measurements of the finish as it progresses in order to achieve the specific flatness and levelness numbers.

13. Acceptance/ Rejection:

- a. If individual slab section measures less than either of specified minimum local F_F/F_L numbers, that section shall be rejected and remedial measures shall be required. Sectional boundaries may be set at construction and contraction (control) joints, and not smaller than one-half bay.
- b. If composite value of entire slab installation, combination of all local results, measures less than either of specified overall F_F/F_L numbers, then whole slab shall be rejected and remedial measures shall be required.

14. Remedial Measures for Rejected Slabs: Correct rejected slab areas by grinding, planing, surface repair with underlayment compound or repair topping, retopping, or removal and replacement of entire rejected slab areas, as directed by Resident Engineer, until a slab finish constructed within specified tolerances is accepted.

3.14 SURFACE TREATMENTS

- A. Use on exposed concrete floors and concrete floors to receive carpeting except those specified to receive non-slip finish.
- B. Liquid Densifier/Sealer: Apply in accordance with manufacturer's directions just prior to completion of construction.
- C. Non-Slip Finish: Except where safety nosing and tread coverings are shown, apply non-slip abrasive aggregate to treads and platforms of concrete steps and stairs, and to surfaces of exterior concrete ramps and platforms. Broadcast aggregate uniformly over concrete surface at rate of application of 8% per 1/10th m² (7.5 percent per square foot) of area. Trowel concrete surface to smooth dense finish. After curing, rub treated surface with abrasive brick and water to slightly expose abrasive aggregate.

3.15 APPLIED TOPPING

- A. Separate concrete topping on floor base slab of thickness and strength shown. Topping mix shall have a maximum slump of 200 mm (8 inches) for concrete containing a high-range water-reducing admixture (superplasticizer) and 100 mm (4 inches) for conventional mix. Neatly bevel or slope at door openings and at slabs adjoining spaces not receiving an applied finish.
- B. Placing: Place continuously until entire section is complete, struck off with straightedge, leveled with a highway straightedge or highway bull float, floated and troweled by machine to a hard dense finish. Slope to floor drains as required. Do not start floating until free water has disappeared and no water sheen is visible. Allow drying of surface moisture naturally. Do not hasten by "dusting" with cement or sand.

3.16 RESURFACING FLOORS

- A. Remove existing flooring areas to receive resurfacing to expose existing structural slab and extend not less than 25 mm (1 inch) below new finished floor level. Prepare exposed structural slab surface by roughening, broom cleaning, and dampening. Apply specified bonding grout. Place topping while the bonding grout is still tacky.

3.17 RETAINING WALLS

- A. Use air-entrained concrete.
- B. Expansion and contraction joints, waterstops, weep holes, reinforcement and railing sleeves installed and constructed as shown.
- C. Exposed surfaces finished to match adjacent concrete surfaces, new or existing.
- D. Place porous backfill as shown.

3.18 PRECAST CONCRETE ITEMS

- A. Precast concrete items, not specified elsewhere. Cast using 25 MPa (3000 psi) air-entrained concrete to shapes and dimensions shown. Finish to match corresponding adjacent concrete surfaces. Reinforce with steel for safe handling and erection.

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SECTION 03 45 00
PRECAST ARCHITECTURAL CONCRETE**PART 1 - GENERAL****1.1 DESCRIPTION**

- A. This section includes the performance criteria, materials, production, and erection of architectural precast concrete cladding units. The work performed under this section includes all labor, material, equipment, related services, and supervision required for the manufacture and erection of the architectural precast concrete work shown on the contract drawings.

1.2 RELATED WORK

- A. Materials testing and inspection during construction: Section 01 45 29, TESTING LABORATORY SERVICES.
- B. Concrete: Section 03 30 00, CAST-IN-PLACE CONCRETE.
- C. Mortar: Section 04 05 13, MASONRY MORTARING, Section 04 05 16, MASONRY GROUTING.
- D. Insulation for Insulated Panels: Section 07 21 13, THERMAL INSULATION.
- E. Sealants and Caulking: Section 07 92 00, JOINT SEALANTS.
- F. Size, type and color of aggregate for exposed aggregate finish and matrix color: Section 09 06 00, SCHEDULE FOR FINISHES.
- G. Repair of abraded galvanized and painted surfaces: Section 09 91 00, PAINTING.
- H. Masonry Facing: Section 04 20 00, UNIT MASONRY.

1.3 QUALITY ASSURANCE

- A. Fabricator Qualifications: A firm that complies with PCI MNL 117 and the following requirements and is experienced in producing units similar to those indicated for this Project and with a record of successful in-service performance:
1. Assumes responsibility for engineering units to comply with performance requirements. A Comprehensive Engineering Analysis shall be performed by a qualified professional engineer who is legally qualified to practice in jurisdiction where Project is located and who is experienced in providing engineering services of the kind indicated.
 2. Participates in PCI's Plant Certification program at the time of bidding and is designated a PCI-certified plant for Group A, Category A1- Architectural Cladding and Load Bearing Units.

3. Has sufficient production capacity to produce required units without delaying the work.

B. Erector Qualifications:

1. A precast concrete erector Qualified by the Precast/Prestressed Concrete Institute (PCI) prior to beginning work at the project site. Submit a current Certificate of Compliance furnished by PCI designating qualification in Category A (Architectural Systems) for non-load-bearing members.
2. An erector with a minimum of 2 years of experience who has completed architectural precast concrete work similar in material, design, and extent to that indicated for this Project and whose work has resulted in construction with a record of successful in-service performance and who meets the following requirements:
 - a. Retains a PCI Certified Field Auditor, at erector's expense, to conduct a field audit of a project in the same category as this Project prior to start of erection. Submits Erectors Post Audit Declaration.
 - b. The basis of the audit is the PCI MNL 127.

C. Quality-Control Standard: For manufacturing procedures and testing requirements, quality-control recommendations, and dimensional tolerances for types of units required, comply with PCI MNL 117.

D. Sample Panels: After sample approval and before fabricating units, produce a minimum of two sample panels approximately 1.5 sq. m. (16 sq. ft.) in size for review by Resident Engineer. Incorporate full scale details of architectural features, finishes, textures, and transitions in the sample panels. Approved sample panel may be used for mockup and range sample.

1. Locate panels where indicated or, if not indicated, as directed by Resident Engineer.
2. Damage part of an exposed-face surface for each finish, color, and texture, and demonstrate adequacy of repair techniques proposed for repair of surface blemishes.
3. After acceptance of repair technique, maintain one sample panel at the manufacturer's plant and one at the project site in an undisturbed condition as a standard for judging the completed work.
4. When back face of precast concrete unit is to be exposed, show samples of the workmanship, color, and texture of the backup concrete as well as the facing.
5. Demolish and remove sample panels only when directed.

- E. Range Samples: After sample panel approval and before production of units, produce a minimum of three samples, approximately 1.5 sq. m. (16 sq. ft.) in size, representing anticipated range of color and texture on project's units. Following range sample acceptance by the Resident Engineer, maintain samples at the manufacturer's plant as color and texture acceptability reference.
- F. Preinstallation Conference: Conduct conference at Project site to comply with requirements in Division 01, GENERAL REQUIREMENTS.

1.4 PERFORMANCE REQUIREMENTS

- A. Structural Performance: Provide units and connections capable of withstanding: the design criteria specified on the drawings, self weights and weights of materials supported or attached, for the conditions indicated.
1. Design Standards: Comply with ACI 318 (ACI 318M) and the design recommendations of PCI MNL 120, applicable to types of units indicated.
 2. Limit deflection of precast members as follows:
Vertical live load - $\text{Span} / 360$.
Wind load - Floor to floor height times 0.0025.
 3. Design for handling, transportation and erection stresses.
- B. Design framing system and connections to maintain clearances at openings, to allow for fabrication and construction tolerances, to accommodate live load deflection, shrinkage and creep of primary building structure, and other building movements.
- C. Thermal Movements: Provide for in-plane thermal movements resulting from annual ambient temperature changes of 27 deg C (80 deg F). Use other values, greater or smaller, whenever justified by climatic conditions at the project site.
- D. Calculated Fire-Test-Response Characteristics: Where indicated, provide units whose fire resistance has been calculated according to PCI MNL 124, and is acceptable to authorities having jurisdiction.

1.5 SUBMITTALS

- A. Product Data: For each type of product indicated. Retain quality control records and certificates of compliance for 5 years or period of warranty, whichever is greater.
- B. Design Mixes: For each concrete mix along with compressive strength and water-absorption tests.
- C. Shop (Erection) Drawings: Detail fabrication and installation of units.

1. Indicate member locations with distinctive marks that match marks placed on the panels. Provide plans, elevations, dimensions, corner details, shapes, cross sections and relationships to adjacent materials.
 2. Indicate aesthetic intent including joints, reveals, and extent and location of each surface finish.
 3. Indicate separate face and backup mix locations, and thicknesses. Indicate locations, extent and treatment of dry joints if two-stage casting is proposed.
 4. Indicate welded connections by AWS standard symbols. Detail loose and cast-in hardware, and connections.
 5. Indicate locations, tolerances and details of anchorage devices to be embedded in or attached to structure or other construction.
 6. Indicate sequence of erection.
 7. Indicate locations and details of facing materials, anchors, and joint widths.
- D. Comprehensive Engineering Analysis: Provide calculations signed and sealed by the qualified professional engineer responsible for the product design. Show governing panel types, connections, and types of reinforcement, including special reinforcement. Indicate design criteria and loads. Indicate the location, type, magnitude and direction of all imposed loadings from the precast system to the building structural frame.
- E. Samples: Design reference samples for initial verification of design intent, approximately 300 by 300 by 50 mm (12 by 12 by 2 inches), representative of finishes, color, and textures of exposed surfaces of units.
- F. Samples for each facing unit required, showing the full range of color and texture expected. Supply sketch of each corner or special shape with dimensions. Supply sample showing color and texture of joint treatment.
- G. Welding Certificates: Copies of certificates for welding procedure specifications (WPS) and personnel.
- H. Qualification Data for fabricator and professional engineer: List of completed projects with project names and addresses, names and addresses of Resident Engineers and owners, and other information specified.
- I. Material Test Reports: From a qualified testing agency indicating and interpreting test results of the following for compliance with requirements indicated:
1. Concrete strengths and mix designs.

J. Material Certificates: Signed by manufacturers certifying that each of the following items complies with requirements.

1. Concrete materials.
2. Reinforcing materials and prestressing tendons.
3. Admixtures.
4. Bearing pads.
5. Structural-steel shapes and hollow structural sections.
6. Insulation
7. Facing units.
8. Anchors.

1.6 PRODUCT DELIVERY, STORAGE AND HANDLING

- A. Product handling requirements of PCI MNL 117 shall be followed at the plant and project site.
- B. Deliver all units to the project site in such quantities and at such times to assure compliance with the agreed project schedule and proper setting sequence so as to limit unloading units temporarily on the ground.
- C. Lift and support units only at designated points shown on the Shop Drawings.
- D. Furnish loose connection hardware and anchorage items to be embedded in or attached to other construction without delaying the Work. Provide setting diagrams, templates, instructions, and directions, as required, for installation.

1.7 WARRANTY

- A. Warranty of precast concrete work, including anchorage, joint treatment and related components to be free from defects in materials and workmanship, including cracking and spalling.
- B. After erection, completed work will be weathertight, subject to terms of Article "Warranty of Construction" FAR clause 52.246-21, except warranty period is extended to five years.

1.8 APPLICABLE PUBLICATIONS

- A. Publications listed below form a part of specification to extent referenced. Publications are referenced in text by basic designation only.
- B. American Society for Testing and Materials (ASTM):
 - A27/A27M-03.....Steel Castings, Carbon, for General Application
 - A36/A36M-04.....Carbon Structural Steel
 - A47/A47M-99.....Ferritic Malleable Iron Castings
 - A82-02.....Steel Wire, Plain, for Concrete Reinforcement

A108-03.....Steel Bar, Carbon and Alloy, Cold-Finished
A123/A123M-02.....Zinc (Hot-Dip Galvanized) Coatings on Iron and
Steel Products
A153/A153M-03.....Zinc Coating (Hot-Dip) on Iron and Steel
Hardware
A167-99.....Stainless and Heat-Resisting Chromium-Nickel
Steel Plate, Sheet, and Strip
A184/A184M-01.....Fabricated Deformed Steel Bar Mats for Concrete
Reinforcement
A185-02.....Steel Welded Wire Fabric, Plain, for Concrete
Reinforcement
A276-04.....Stainless Steel Bars and Shapes
A283/A283M-03.....Low and Intermediate Tensile Strength Carbon
Steel Plates
A307-03.....Carbon Steel Bolts and Studs, 60 000 PSI Tensile
Strength
A325/A325M-04.....Structural Bolts, Steel, Heat Treated, 120/105
ksi Minimum Tensile Strength
A416/A416M-02.....Steel strand, Uncoated Seven-Wire for
Prestressed Concrete
A490/A490M-04.....Structural Bolts, Alloy Steel, Heat Treated, 150
ksi Minimum Tensile Strength
A496-02.....Steel Wire, Deformed, for Concrete Reinforcement
A497-02.....Steel Welded Wire Reinforcement, Deformed, for
Concrete
A500-03a.....Cold-Formed Welded and Seamless Carbon Steel
Structural Tubing in Rounds and Shapes
A563/A563M-04.....Carbon and Alloy Steel Nuts
A572/A572M-04.....High-Strength Low-Alloy Columbium-Vanadium
Structural Steel
A615/A615M-04a.....Deformed and Plain Billet-Steel Bars for
Concrete Reinforcement
A666-03.....Annealed or Cold-Worked Austenitic Stainless
Steel Sheet, Strip, Plate, and Flat Bar
A675/A675M-03.....Steel Bars, Carbon, Hot-Wrought, Special
Quality, Mechanical Properties
A706/A706M-04a.....Low-Alloy Steel Deformed and Plain Bars for
Concrete Reinforcement
A767/A767M-00b.....Zinc-Coated (Galvanized) Steel Bars for Concrete
Reinforcement

A775/A775M-04.....Epoxy-Coated Steel Reinforcing Bars

A780-01.....Repair of Damaged and Uncoated Areas of Hot-Dip
Galvanized Coatings

A884/A884M-02.....Epoxy-Coated Steel Wire and Welded Wire Fabric
for Reinforcement

A934/A934M-04.....Epoxy-Coated Prefabricated Steel Reinforcing
Bars

B227-04.....Hard-Drawn Copper-Clad Steel Wire

B633-98e1.....Electrodeposited Coatings of Zinc on Iron and
Steel

C33-03.....Concrete Aggregates

C40-04.....Organic Impurities in Fine Aggregate for
Concrete

C150-04.....Portland Cement

C260-01.....Air-Entraining Admixtures for Concrete

C330-04.....Lightweight Aggregates for Structural Concrete

C373-88(99).....Test Method for Water Absorption, Bulk Density,
Apparent Porosity, and Apparent Specific Gravity
of Fired Whiteware Products

C494/C494M-01.....Chemical Admixtures for Concrete

C618-03.....Coal Fly Ash and Raw or Calcined Natural
Pozzolan for Use as a Mineral Admixture in
Concrete

C881/C881M-02.....for Epoxy-Resin-Base Bonding Systems for
Concrete

C979-99.....Pigments for Integrally Colored Concrete

C989-04.....Ground Granulated Blast-Furnace Slag for Use in
Concrete and Mortars

C1017/C1017M-03.....Chemical Admixtures for Use in Producing Flowing
Concrete

C1107-02.....Packaged Dry, Hydraulic-Cement Grout (Nonshrink)

C1218/C1218M-99.....Test Method for Water-Soluble Chloride in Mortar
and Concrete

C1240-04.....Silica Fume Used in Cementitious Mixtures

D412-98(02)e1.....Test Methods for Vulcanized Rubber and
Thermoplastic Elastomers—Tension

D2240-03.....Test Method for Rubber Property—Durometer
Hardness

F436/F436M-03.....Hardened Steel Washers

- F568M-02.....Carbon and Alloy Steel Externally Threaded
Metric Fasteners
- F593-02(04)e1.....Stainless Steel Bolts, Hex Cap Screws, and Studs
- F844-00.....Washers, Steel, Plain (Flat), Unhardened for
General Use
- C. American Concrete Institute (ACI):
- ACI 211.1-91.....Selecting Proportions for Normal, Heavyweight
and Mass Concrete (Reapproved 2002)
- ACI 318/318M-02 (318R/318RM-02) Building Code Requirements for
Structural Concrete
- D. American Association of State Highway and Transportation Officials
- AASHTO LFRD-2004.....LRFD Bridge Design Specifications, U.S., 3rd
Edition
- AASHTO M251-97(R2001) Elastomeric Bearings
- E. Precast/Prestressed Concrete Institute (PCI):
- MNL-117-96.....Quality Control for Plants and Production of
Architectural Precast Concrete Products
- MNL-120-99.....Design Handbook - Precast and Prestressed
Concrete
- MNL-124-89.....Design for Fire Resistance of Precast
Prestressed Concrete.
- MNL-127-99.....Erector's Manual - Standards and Guidelines for
the Erection of Precast Concrete Products
- MNL-135-00.....Tolerance Manual for Precast and Prestressed
Concrete Construction
- TR-6-03.....Interim Guidelines for the Use of Self-
Consolidating Concrete
- F. Military Specifications (MIL. Spec):
- MIL-C882E-89.....Cloth, Duck, Cotton or Cotton-Polyester Blend
Synthetic Rubber, Impregnated, and Laminated,
Oil Resistant.
- G. Structural Steel Painting Council (SSPC):
- SSPC-Paint 20 (2002). Zinc-Rich Primers (Type I, Inorganic, and Type
II, Organic).

PART 2 - PRODUCTS

2.1 MOLD MATERIALS

- A. Molds: Rigid, dimensionally stable, nonabsorptive material, warp and
buckle free, that will provide continuous and true precast concrete

surfaces within fabrication tolerances indicated; non-reactive with concrete and suitable for producing required finishes:

1. Mold-Release Agent: Commercially produced liquid-release agent that will not bond with, stain or adversely affect precast concrete surfaces and will not impair subsequent surface or joint treatments of precast concrete.

2.2 REINFORCING MATERIALS

- A. Reinforcing Steel: ASTM A615/A615M, Grade 60 (Grade 420), deformed.
- B. Weldable Reinforcing Bars: ASTM A706/A706M, deformed.
 1. Galvanized Reinforcing Bars: ASTM A767/A767M, Class II zinc coated, hot-dip galvanized and chromate wash treated after fabrication and bending.
 2. Epoxy-Coated Reinforcing Bars: ASTM A775/A775M or ASTM A934/A934M.
 3. Steel Bar Mats: ASTM A184/A184M, assembled with clips.
 - a. Deformed-Steel Welded Wire Reinforcement: ASTM A497, flat sheet.
- C. Epoxy-Coated-Steel Welded Wire Reinforcement: ASTM A884/A884M Class A coated, plain on flat sheet, Type 1 bendable coating.
- D. Supports: Suspend reinforcement from back of mold or use bolsters, chairs, spacers, and other devices for spacing, supporting, and fastening reinforcing bars and welded wire reinforcement in place according to PCI MNL 117.

2.3 CONCRETE MATERIALS

- A. Portland Cement: ASTM C150, Type I or III.
 1. For surfaces exposed to view in finished structure, use white, same type, brand, and mill source throughout the precast concrete production.
 2. Standard gray Portland cement may be used for non-exposed backup concrete.
- B. Supplementary Cementitious Materials for unexposed surfaces (backup concrete) only.
 1. Fly Ash Admixture: ASTM C618, Class C or F with maximum loss on ignition of 3 percent.
 2. Ground Granulated Blast-Furnace Slag: ASTM C989, Grade 100 or 120.
- C. Normal-Weight Aggregates: Except as modified by PCI MNL 117, ASTM C33, with coarse aggregates complying with Class 5S. Provide and stockpile fine and coarse aggregates for each type of exposed finish from a single source (pit or quarry) for entire project.

1. Face-Mix Coarse Aggregates: Selected, hard, and durable; free of material that reacts with cement or causes staining; to match selected finish sample.
 - a. Gradation: Uniformly graded.
 - b. Hard durable, quartz, marble, granite, siliceous stone, aggregate carefully graded from coarse to fine in proportions required to match approved samples.
 - c. Eliminate off color material from exposed aggregate.
2. Face-Mix Fine Aggregates: Selected, natural or manufactured sand of the same material as coarse aggregate, unless otherwise approved by Resident Engineer.
 - a. Test sand for color value in accordance with ASTM C40. Sand producing darker than specified color standard is unacceptable.
 - b. Clean washed white sand.
- D. Unexposed Surface (Backup) Concrete Aggregates: ASTM C33.
- E. Admixtures: Admixtures containing calcium chloride, or more than 0.15 percent chloride ions or other salts by weight of admixture are not permitted.
 1. Coloring Admixture: ASTM C979, synthetic or natural mineral-oxide pigments or colored water-reducing admixtures, temperature stable and non-fading.
 2. Air Entraining Admixture: ASTM C260, certified by manufacturer to be compatible with other required admixtures.
 3. Water-Reducing Admixture: ASTM C494/C494M, Type A.
 4. Retarding Admixture: ASTM C494/C494M, Type B.
 5. Water-Reducing and Retarding Admixture: ASTM C494/C494M, Type D.
 6. High-Range, Water-Reducing Admixture: ASTM C494/C494M, Type F.
 7. High-Range, Water-Reducing and Retarding Admixture: ASTM C494/C494M, Type G.
 8. Plasticizing Admixture for Flowable Concrete: ASTM C1017/C1017M.
- F. Water: Potable; free from deleterious material that may affect color stability, setting, or strength of concrete and complying with chemical limits of PCI MNL 117.

2.4 STEEL CONNECTION MATERIALS

- A. Carbon-Steel Shapes and Plates: ASTM A36/A36M except silicon (Si) content in the range of 0 to 0.03% or 0.15 to 0.25% for materials to be galvanized. Steel with chemistry conforming to the formula $Si + 2.5P \leq 0.09$ is also acceptable.
- B. Carbon-Steel Headed Studs: ASTM A108, Grades 1018 through 1020, cold finished and bearing the minimum mechanical properties for studs as

indicated under PCI MNL 117, Table 3.2.3.; AWS D1.1, Type A or B, with arc shields.

- C. Carbon-Steel Plate: ASTM A283/A283M.
- D. Malleable Iron Castings: ASTM A47/A47M. Grade 32510.
- E. Carbon-Steel Castings: ASTM A27/A27M, Grade U-60-30 (Grade 415-205).
- F. High-Strength, Low-Alloy Structural Steel: ASTM A572/A572M except silicon (Si) content in the range of 0 to 0.03% or 0.15 to 0.25% for materials to be galvanized. Steel with chemistry conforming to the formula $Si + 2.5P \leq 0.09$ is also acceptable.
- G. Carbon-Steel Structural Tubing: ASTM A500, Grade B.
- H. Wrought Carbon-Steel Bars: ASTM A675/A675M, Grade 65 (Grade 450).
- I. Deformed-Steel Wire or Bar Anchors: ASTM A496 or ASTM A706/A706M.
- J. Carbon-Steel Bolts and Studs: ASTM A307, Grade A (ASTM F568M, Property Class 4.6) carbon-steel, hex-head bolts and studs; carbon-steel nuts (ASTM A563/A563M, Grade A); and flat, unhardened steel washers (ASTM F844).
- K. High-Strength Bolts and Nuts: ASTM A325/A325M or ASTM A490/A490M, Type 1, heavy hex steel structural bolts, heavy hex carbon-steel nuts, (ASTM A563/A563M) and hardened carbon-steel washers (ASTM F436/F436M).
- L. Finish: For exterior steel items and items indicated for galvanizing, apply zinc coating by hot-dip process according to ASTM A123/A123M, after fabrication, or ASTM A153/A153M, as applicable.
 - 1. Galvanizing Repair Paint: High-zinc-dust-content paint with dry film containing not less than 94 percent zinc dust by weight, and complying with SSPC-Paint 20.
- M. Welding Electrodes: Comply with AWS standards.

2.5 STAINLESS-STEEL CONNECTION MATERIALS

- A. Stainless-Steel Plate: ASTM A666, Type 304, of grade suitable for application.
- B. Stainless-Steel Bolts and Studs: ASTM F593, alloy 304 or 316, hex-head bolts and studs; stainless-steel nuts; and flat, stainless steel washers. Lubricate threaded parts of stainless steel bolts with an anti-seize thread lubricant during assembly.
- C. Stainless-Steel Headed Studs: ASTM A276 and bearing the minimum mechanical properties for studs as indicated under PCI MNL 117, Table 3.2.3.

2.6 BEARING PADS AND OTHER ACCESSORIES

- A. Provide bearing pads for units as follows:

1. Elastomeric Pads: AASHTO M251, plain, vulcanized, 100 percent polychloroprene (neoprene) elastomer, molded to size or cut from a molded sheet, 50 to 70 Shore A durometer according to ASTM D2240, minimum tensile strength 15.5 MPa (2250 psi) per ASTM D412.
2. Random-Oriented, Fiber-Reinforced Elastomeric Pads: Preformed, randomly oriented synthetic fibers set in elastomer. Surface hardness of 70 to 90 Shore A durometer according to ASTM D2240. Capable of supporting a compressive stress of 20.7 MPa (3000 psi) with no cracking, splitting or delaminating in the internal portions of the pad. Test one specimen for each 200 pads used in the project.
3. Cotton-Duck-Fabric-Reinforced Elastomeric Pads: Preformed, horizontally layered cotton-duck fabric bonded to an elastomer. Surface hardness of 80 to 100 Shore A durometer according to ASTM D2240. Conforming to Division II, Section 18.10.2 of AASHTO LFRD, or MIL-C-882E.
4. Frictionless Pads: Tetrafluoroethylene (teflon), glass-fiber reinforced, bonded to stainless or mild-steel plates, of type required for in-service stress.
5. High-Density Plastic: Multimonomer, nonleaching, plastic strip.
- B. Reglets: Stainless steel, ASTM A167, Type 302 felt or fiber filled or cover face opening of slots.
- C. Vents and Weeps: Polyvinyl chloride plastic tubing, 9.5 mm (3/8-inch) inside diameter.
- D. Accessories: Provide clips, hangers, plastic or steel shims, and other accessories required to install units.

2.7 GROUT MATERIALS

- A. Sand-Cement Grout: Portland Cement, ASTM C150, Type I, and clean, natural sand, ASTM C144, or ASTM C404. Mix at ratio of 1 part cement to 2-1/2 parts sand, by volume, with minimum water required for placement and hydration.
- B. Nonmetallic, Nonshrink Grout: Premixed, nonmetallic, noncorrosive, nonstaining grout containing selected silica sands, portland cement, shrinkage-compensating agents, plasticizing and water-reducing agents, complying with ASTM C1107, Grade A for drypack and Grades B and C for flowable grout and of a consistency suitable for application within a 30-minute working time.
- C. Epoxy-resin grout: Two-component mineral-filled epoxy-resin: ASTM C881 of type, grade, and class to suit requirements.

2.8 CONCRETE MIXES

- A. Prepare design mixes to match Resident Engineer's sample for each type of concrete required.
 - 1. Limit use of fly ash and granulated blast-furnace slag to 20 percent replacement of Portland cement by weight.
- B. Design mixes shall be prepared by a qualified independent testing agency or by qualified precast plant personnel at fabricator's option.
- C. Limit water-soluble chloride ions to the maximum percentage by weight of cement permitted by ACI 318 (ACI 318M) or PCI MNL 117 when tested in accordance with ASTM C1218/C1218M.
- D. Proportion mixes by either laboratory trial batch or field test data methods according to ACI 211.1, with materials to be used on project, to provide normal-weight concrete with the following properties:
 - 1. Compressive Strength (28 Days): 34.5 MPa (5000 psi).
 - 2. Maximum Water-Cementitious Materials Ratio: 0.45.
 - 3. Release Strength at Transfer of Prestress: 24.1 MPa (3500 psi).
- E. Water Absorption: 6 percent by weight or 14 percent by volume, tested according to PCI MNL 117.
- F. Add air-entraining admixture at manufacturer's prescribed rate to result in concrete at point of placement having an air content complying with PCI MNL 117.
- G. When included in design mixes, add other admixtures to concrete mixes according to manufacturer's written instructions.

2.9 MOLD FABRICATION

- A. Molds: Accurately construct and maintain molds, mortar tight, within fabrication tolerances and of sufficient strength to withstand pressures due to concrete-placement and vibration operations and temperature changes and for prestressing and detensioning operations.
 - 1. Form joints are not permitted on faces exposed to view in the finished work.
 - 2. Edge and Corner Treatment: Uniformly.
 - 3. Coat contact surfaces of molds with release agent before reinforcement is placed. Avoid contamination of reinforcement and prestressing tendons by release agent.

2.10 FABRICATION

- A. Cast-in Anchors, Inserts, Plates, Angles, and Other Anchorage Hardware: Fabricate anchorage hardware with sufficient anchorage and embedment to comply with design requirements. Accurately position for attachment of loose hardware and secure in place during precasting operations. Locate

anchorage hardware where it does not affect position of main reinforcement or concrete placement.

Weld headed studs and deformed bar anchors used for anchorage.

- B. Furnish loose hardware items including steel plates, clip angles, seat angles, anchors, dowels, cramps, hangers, and other hardware shapes for securing units to supporting and adjacent construction.
- C. Cast-in reglets, slots, holes, and other accessories in units as indicated.
- D. Cast-in openings larger than 250 mm (10 inches) in any dimension. Do not drill or cut openings or reinforcing without approval of Resident Engineer.
- E. Reinforcement: Comply with recommendations in PCI MNL 117 for fabrication, placing, and supporting reinforcement.
 - 1. Place reinforcing steel and prestressing strand to maintain at least 19 mm (3/4 inch) minimum concrete cover. Arrange, space, and securely tie bars and bar supports to hold reinforcement in position while placing concrete.
 - 2. Install welded wire reinforcement in lengths as long as practicable. Lap adjoining pieces at least one full mesh spacing and wire tie laps, where required by design. Offset laps of adjoining widths to prevent continuous laps in either direction.
- F. Mix concrete according to PCI MNL 117 and requirements in this Section. After concrete batching, no additional water may be added.
- G. Place concrete in a continuous operation to prevent seams or planes of weakness from forming in precast concrete units. Comply with requirements in PCI MNL 117.
- H. Identify pickup points of units and orientation in structure with permanent markings, complying with markings indicated on Shop Drawings.

Imprint or permanently mark casting date on each unit on a surface that will not show in finished structure.
- I. Cure concrete, according to requirements in PCI MNL 117, by moisture retention without heat or by accelerated heat curing using low-pressure live steam or radiant heat and moisture.
- J. Repair damaged units to meet acceptability requirements of PCI MNL 117 and the Resident Engineer.

2.11 INSULATED PANEL CASTING

- A. Cast and screed supported wythe over mold.
- B. Place insulation boards, abutting edges and ends of adjacent boards.

Insert wythe connectors through insulation, and consolidate concrete

around connectors according to connector manufacturer's written instructions.

C. Cast and screed top wythe to meet required finish.

2.12 FABRICATION TOLERANCES

- A. Fabricate units straight and true to size and shape with exposed edges and corners precise and true so each finished unit complies with PCI MNL 117 product tolerances as well as position tolerances for cast-in items.
 - 1. Additional Position Tolerances: For cast-in items measured from datum line location, as indicated on Shop Drawings.
 - a. Position of Sleeve: Plus or Minus 13 mm (1/2 inch).
- B. Fabricate architectural trim units such as sills and copings, with tolerances meeting PCI MNL 135.

2.13 FINISHES

- A. Panel faces shall be free of joint marks, grain, and other obvious defects. Corners, including false joints shall be uniform, straight and sharp. Finish exposed-face surfaces of units to match approved design reference sample panels and as follows:
 - 1. PCI's "Architectural Precast Concrete -Color and Texture Selection Guide," of plate numbers indicated.
 - 2. As-Cast Surface Finish: Provide surfaces free of excessive air voids, sand streaks, and honeycombs.
 - 3. Honed Finish: Use continuous mechanical abrasion with fine grit, followed by filling and rubbing procedures.
- B. Finish exposed top, bottom, surfaces of units to match face-surface finish.
- C. Finish unexposed surfaces of units by float finish.

2.14 SOURCE QUALITY CONTROL

- A. Quality-Control Testing: Test and inspect precast concrete according to Section 01 45 29, TESTING LABORATORY SERVICES and PCI MNL 117 requirements respectively. If using self-consolidating concrete also test and inspect according to PCI TR-6.
- B. Testing: If there is evidence that the concrete strength of precast concrete units may be deficient, Precaster will employ an independent testing agency to obtain, prepare, and test cores drilled from hardened concrete to determine compressive strength according to PCI MNL 117:
 - 1. Test results will be made in writing on the same day that tests are performed, with copies to Resident Engineer, Contractor, and precast concrete fabricator. Test reports will include the information required in Section TESTING LABORATORY SERVICES and the following:

- a. Identification mark and type of precast concrete units represented by core tests; design compressive strength; type of break; compressive strength at breaks, corrected for length-diameter ratio; and direction of applied load to core in relation to horizontal plane of concrete as placed.
- C. Defective or Damaged Work: Units that do not comply with acceptability requirements, including concrete strength, manufacturing tolerances, and color and texture range are unacceptable. Chipped, spalled or cored units may be repaired, if repaired units match the visual mock-up. The Resident Engineer reserves the right to reject any unit if it does not match the accepted samples and visual mock-up. Replace unacceptable units with precast concrete units that comply with requirements.

PART 3 - EXECUTION

3.1 PREPARATION

- A. Deliver anchorage devices that are embedded in or attached to the building structural frame or foundation before start of such work. Provide locations, setting diagrams, and templates for the proper installation of each anchorage device.
- B. Examine supporting structural frame or foundation and conditions for compliance with requirements for installation tolerances, true and level bearing surfaces, and other conditions affecting performance. Proceed with installation only after unsatisfactory conditions have been corrected.
- C. Do not install units until supporting cast in place foundations has attained minimum allowable design strength or supporting steel or other structure is structurally ready to receive loads from precast.

3.2 ERECTION

- A. Erect level, plumb and square within the specified allowable tolerances. Provide temporary supports and bracing as required to maintain position, stability, and alignment of units until permanent connections are completed.
 - 1. Install temporary steel or plastic spacing shims or bearing pads as precast concrete units are being erected. Tack weld steel shims to each other to prevent shims from separating.
 - 2. Maintain horizontal and vertical joint alignment and uniform joint width as erection progresses.
 - 3. Remove projecting lifting devices and use sand-cement grout to fill voids within recessed lifting devices flush with surface of adjacent precast concrete surfaces when recess is exposed.

4. Unless otherwise shown provide for uniform joint widths of 19 mm (3/4 inch).
- B. Connect units in position by bolting, welding, grouting, or as otherwise indicated on approved Erection Drawings. Remove temporary shims, wedges, and spacers as soon as practical after connecting and/or grouting are completed.
 1. Disruption of roof flashing continuity by connections is not permitted; concealment within roof insulation is acceptable.
 2. Welding: Comply with applicable requirements for welding.
 - a. Protect units and bearing pads from damage by field welding or cutting operations and provide noncombustible shields as required.
 - b. Welds not specified shall be continuous fillet welds, using not less than the minimum fillet as specified by AWS.
 - c. Clean weld affected metal surfaces and apply a minimum 100 μ m (0.004 inch) thick coat of galvanized repair paint to galvanized surfaces in conformance with ASTM A780.
 - d. Visually inspect all welds critical to precast connections. Visually check all welds for completion and remove, reweld or repair all defective welds.
 3. At bolted connections, use lock washers, tack welding, or other acceptable means to prevent loosening of nuts after final adjustment.
 - a. Where slotted connections are used, verify bolt position and tightness. For sliding connections, properly secure bolt but allow bolt to move within connection slot. For friction connection apply specified bolt torque and check 25 percent of bolts at random by calibrated torque wrench.
 4. Grouting Connections: Grout connections where required or indicated. Retain grout in place until hard enough to support itself. Pack spaces with stiff grout material, tamping until voids are completely filled. Place grout to finish smooth, level, and plumb with adjacent concrete surfaces. Promptly remove grout material from exposed surfaces before it affects finishes or hardens.
- C. Attachments: Upon approval of Resident Engineer, precast pre-stressed products may be drilled or "shot" for fasteners or small openings. Provided reinforcing or pre-stressing steel is not damaged or cut.
 1. Should spalling occur, repair according to this specification section.
- D. Venting and Weeps: Where precast concrete panels form the outer wythe of cavity wall construction, vent the cavity wall.
 1. Use polyvinyl chloride plastic tubing to vent the cavity.

2. Place plastic vent tubes "tilted down and out" in horizontal and vertical joints.
 3. Space vent tubes in accordance with shop drawings, but not less than two vents per panel or approximately 1220 mm (4 feet) on centers.
- E. Setting: Where shown, fill joints with cement mortar specified in Section 04 05 13, MASONRY MORTARING; Section 04 05 16, MASONRY GROUTING.
1. Clean surfaces forming beds and other joints for precast concrete panels of dust, dirt, and other foreign matter, and wet thoroughly to prevent suction before precast concrete elements are set.
 2. Set precast element level and true to line with uniform joints filled completely with mortar.
Rake out joints 25 mm (1-inch) deep for pointing or sealants.
Joints required to have only sealant: Kept free of mortar for full depth.
 3. Keep exposed faces of precast concrete elements free of mortar.
 4. Remove wedges, spacers, or other appliances which are likely to cause staining from joints.
 5. Where parging is shown, parge back of elements solid with mortar.
Apply parging without skips or holidays.
- F. Pointing: Wash and brush clean, leaving joints free from loose mortar, dust and other foreign material.
1. Carefully point with a slightly concave joint.
 2. Mortar for pointing as specified in Section 04 05 13, MASONRY MORTARING; Section 04 05 16, MASONRY GROUTING. Use same material and color sand used in fabrication of precast concrete elements when specified in Section 09 06 00, SCHEDULE FOR FINISHES.
- G. Sealing of Joints: Where shown and where required to make work watertight: clean, dry and seal joints between precast concrete elements and between precast elements and adjoining materials as specified in Section 07 92 00, JOINT SEALANTS.

3.3 ERECTION TOLERANCES

- A. Erect units level, plumb, square, true, and in alignment without exceeding the erection tolerances of PCI MNL 117, Appendix I.

3.4 FIELD QUALITY CONTROL

- A. Refer to Section 01 45 29, TESTING LABORATORY SERVICES.
- B. Testing agency will report test results promptly and in writing to Contractor and Resident Engineer.
- C. Repair or remove and replace work that does not comply with specified requirements.

- D. Additional testing and inspecting, at Contractor's expense, will be performed to determine compliance of corrected work with specified requirements.

3.5 REPAIRS

- A. Repairs will be permitted provided structural adequacy of units and appearance are not impaired.
- B. Mix patching materials and repair units so cured patches blend with color, texture, and uniformity of adjacent exposed surfaces and show no apparent line of demarcation between original and repaired work, when viewed in typical daylight illumination from a distance of 6 m (20 feet).
- C. Prepare and repair damaged galvanized coatings with galvanizing repair paint according to ASTM A780.
- D. Remove and replace damaged units when repairs do not meet requirements.

3.6 CLEANING

- A. Clean all surfaces of precast concrete to be exposed to view, as necessary, prior to shipping.
- B. Clean mortar, plaster, weld slag, and any other deleterious material from concrete surfaces and adjacent materials immediately.
- C. Clean exposed surfaces of precast concrete units after erection and completion of joint treatment to remove weld marks, other markings, dirt, and stains.
1. Perform cleaning procedures, if necessary, according to precast concrete fabricator's recommendations. Clean soiled precast concrete surfaces with detergent and water, using stiff fiber brushes and sponges, and rinse with clean water. Protect other work from staining or damage due to cleaning operations.
 2. Do not use cleaning materials or processes that could change the appearance of exposed concrete finishes or damage adjacent materials.

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